

1. A flooring product comprising:
 - a vinyl layer having a bottom layer portion and a top portion; and
 - a skeletal frame having a pattern of runners disposed about openings, said runners having a height between a top surface and a bottom surface, said skeletal frame imbedded into the top layer portion of the vinyl sheet layer wherein bubbles are formed in the top portion of the vinyl sheet layer and have a top surface which extend a distance above the bottom surface of the skeletal frame and into the openings, and the bottom layer portion forms a non-porous sheet below the skeletal frame and top portion of the vinyl layer.
2. The flooring product of claim 1 wherein the pattern of the skeletal frame is a repeating pattern.
3. The flooring product of claim 1 wherein the top surface of the bubbles extend a distance above the top surface of the runners of the skeletal frame and completely fill the openings between the runners.
4. The flooring product of claim 3 wherein the bubbles overhang at least a portion of the top surface of the runners of the skeletal frame.
5. The flooring product of claim 4 wherein the bubbles completely cover the top surface of the runners and have valleys extending above the top portion of the skeletal frame.

6. The flooring product of claim 1 wherein the skeletal frame is imbedded at several depths relative to the top portion of the vinyl layer to create a particular design.
7. The flooring product of claim 1 wherein the openings between the runners are substantially filled with the top portion of the vinyl layer.
8. The flooring product of claim 1 wherein the skeletal frame is a metal screen.
9. The flooring product of claim 1 wherein the skeletal frame is a nylon mesh.
10. The flowing product of claim 1 wherein the bubbles extend to fill the openings to a first depth throughout the openings.